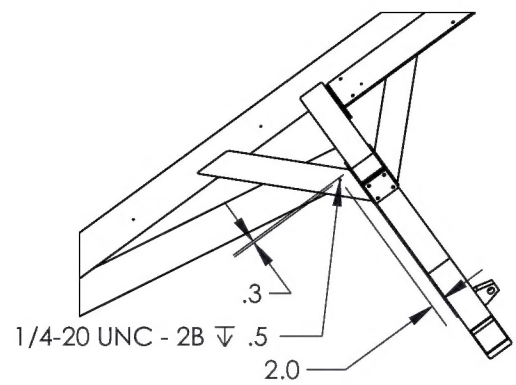
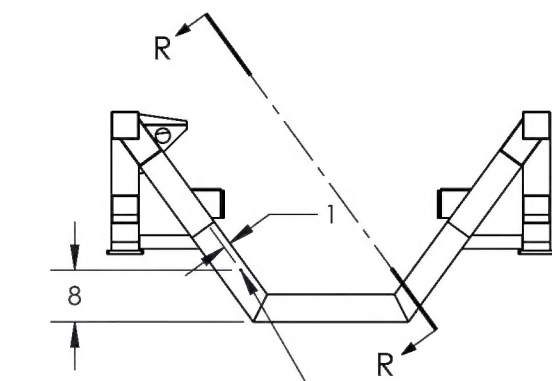


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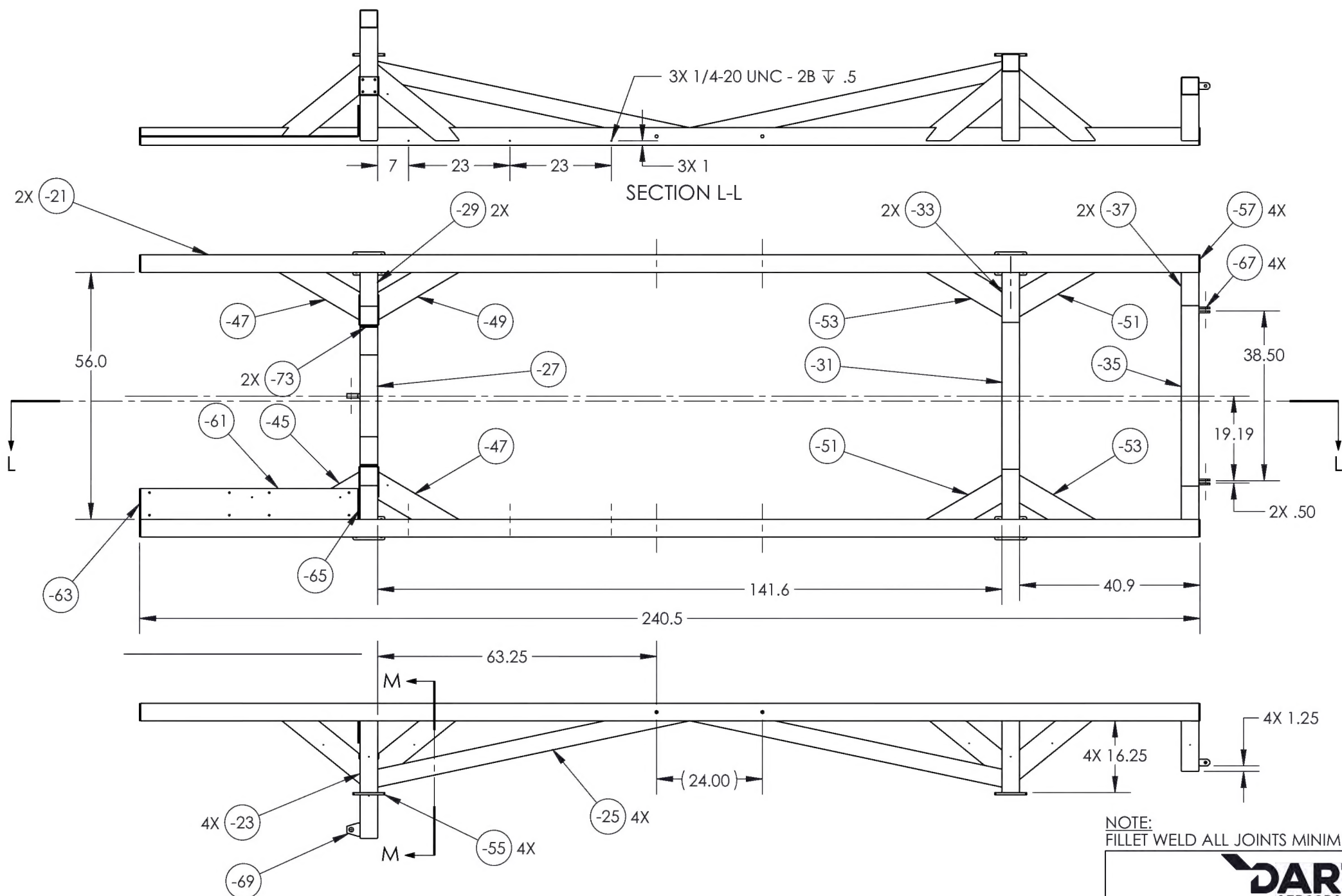
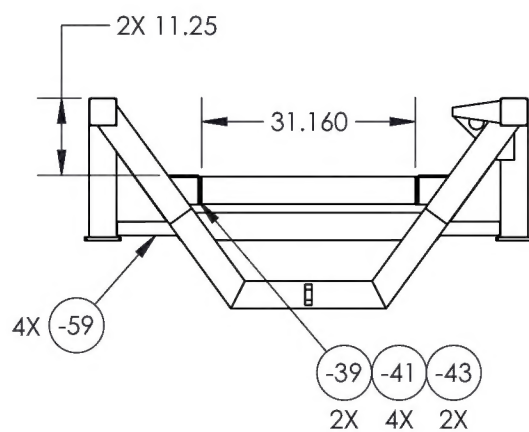
REVISIONS			DATE	INITIAL	APPROVED
REV	ECR	DESCRIPTION			
1		RELEASED FOR PRODUCTION.	4/27/2017	SM	JAG



SECTION R-R



SECTION M-M



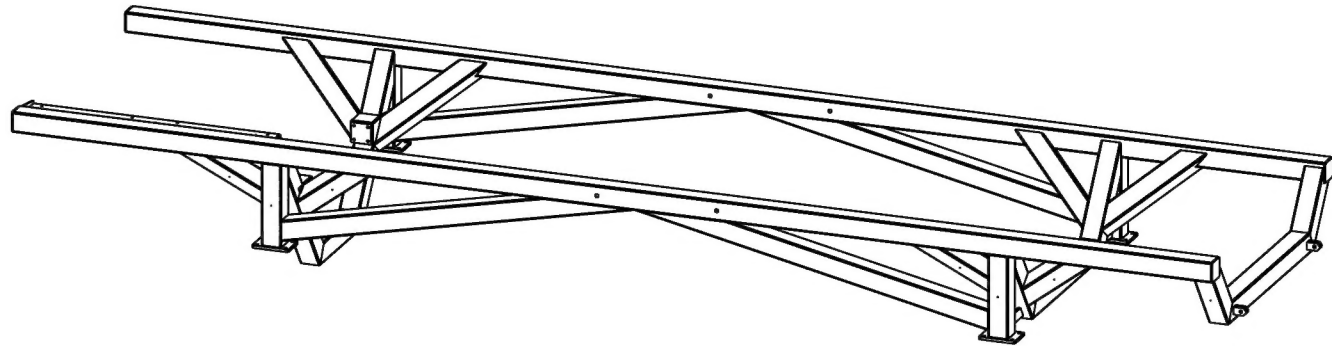
MAIN FRAME

NOTE:  
FILLET WELD ALL JOINTS MINIMUM 90%.

DART AEROSPACE		
TITLE SUPPORT DOLLY, TAILBOOM		
DWG NO. RB T102012-1	REV 1	
MAT'L HEAT TREAT FINISH SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125/	
DRAWN BY: CHECKED: OPPS APPR: QA APPR: APPROVED:	GILBERT CLOUGH ANDERSON LINDSAY GILBERT	
SCALE 1:28	DATE 3/13/2014	SHEET 1 OF 29

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REV	ECR	DESCRIPTION	DATE



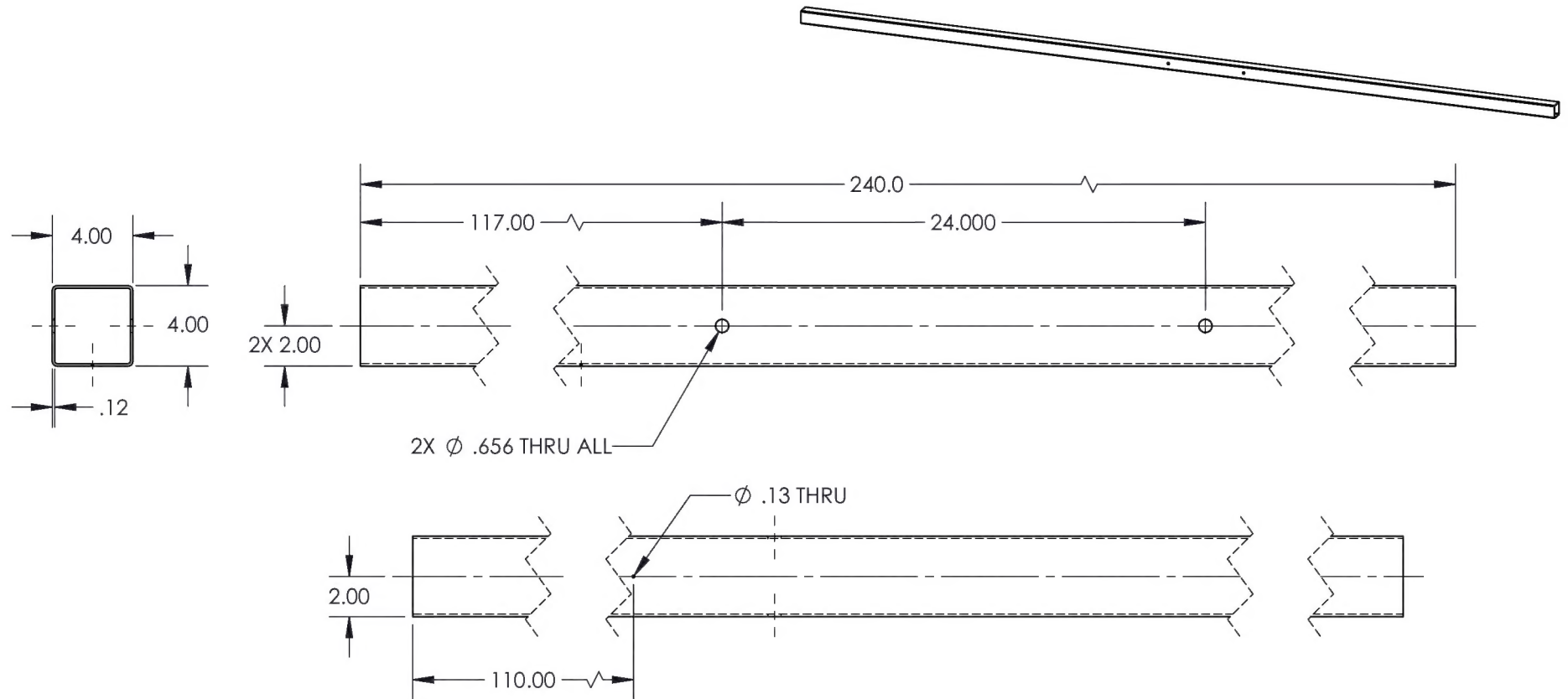
ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-21	2	TOP RAIL	STEEL TUBE		3
			-23	4	MAIN FRAME UPRIGHT	STEEL TUBE		4
			-25	4	MAIN FRAME OUTSIDE BRACE	STEEL TUBE		5
			-27	1	MAIN FRAME 1 BOTTOM	STEEL TUBE		6
			-29	2	MAIN FRAME 1 SIDE	STEEL TUBE		7
			-31	1	MAIN FRAME 2 BOTTOM	STEEL TUBE		8
			-33	2	MAIN FRAME 2 SIDE	STEEL TUBE		9
			-35	1	MAIN FRAME 3 BOTTOM	STEEL TUBE		10
			-37	2	MAIN FRAME 3 SIDE	STEEL TUBE		11
			-39	2	MAIN FRAME 1 PIVOT	STEEL TUBE		12
			-41	4	MAIN FRAME 1 PIVOT SIDE REINFORCEMENT	A36/1018/1020 HR		13
			-43	2	MAIN FRAME 1 PIVOT TOP REINFORCEMENT	A36/1018/1020 HR		14
			-45	1	MAIN FRAME INSIDE BRACE POWER PACK	STEEL TUBE		15
			-47	2	MAIN FRAME INSIDE BRACE MIRROR	A36/1018/1020 HR		16
			-49	1	MAIN FRAME INSIDE BRACE	STEEL TUBE		17
			-51	2	MAIN FRAME TB INSIDE BRACE	STEEL TUBE		18
			-53	2	MAIN FRAME TB INSIDE BRACE MIRROR	STEEL TUBE		19
			-55	4	MAIN FRAME WHEEL PLATE	A36/1018/1020 HR		20
			-57	4	MAIN FRAME END CAP	A36/1018/1020 HR		21
			-59	4	MAIN FRAME 2 UPRIGHT BRACE	A36/1018/1020 HR		22
			-61	1	MAIN FRAME POWER PACK BASE	A36/1018/1020 HR		23
			-63	1	MAIN FRAME POWER PACK GUSSET	A36/1018/1020 HR		24
			-65	1	MAIN FRAME POWER PACK GUSSET 2	A36/1018/1020 HR		25
			-67	4	MAIN FRAME TOWBAR MOUNT	A36/1018/1020 HR		26
			-69	1	MAIN FRAME 1 PISTON TAB	A36/1018/1020 HR		27
	X		-73	2	WELDED PIVOT PLATE ASSEMBLY			28
	1		-75		MAIN FRAME WELD PIVOT PLATE	A36/1018/1020 HR		29
	4	B/O	-77		HEX NUT	STEEL	3/8-24 (MCMASTER-CARR #90499A815)	28
	-73 ASSY							



TITLE		SUPPORT DOLLY, TAILBOOM	
DWG NO.		RB T102012-1	
REV		1	
MAT'L		UNLESS OTHERWISE SPECIFIED	
TREAT		DIMENSIONS ARE IN INCHES	
FINISH		.XXX ± .010 FRACTIONS ± 1/8	
SPEC		.XX ± .03 ANGLES ± 1°	
FED #13538		.X ± .1 SURFACES = 125°	
DRAWN BY:		GILBERT	
CHECKED:		CLOUGH	
OPPS APPR:		ANDERSON	
QA APPR:		LINDSAY	
APPROVED:		GILBERT	
SCALE		1:36	
DATE		3/13/2014	
SHEET		2 OF 29	

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			INITIAL
			APPROVED



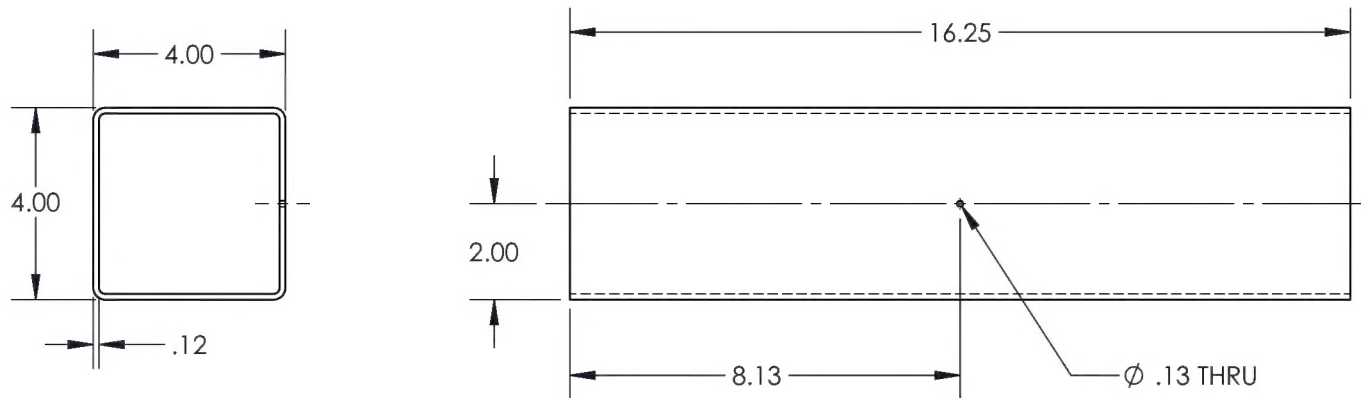
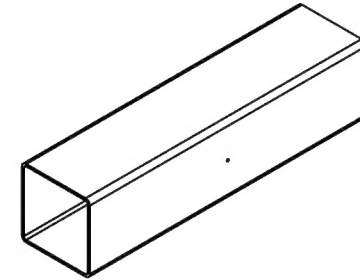
(21)

TOP RAIL

<b>DART</b> AEROSPACE	
TITLE <b>SUPPORT DOLLY, TAILBOOM</b>	
DWG NO. <b>RB T102012-21</b>	REV <b>1</b>
MAT'L STEEL TUBE	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -1 WELDMENT	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125°
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:8	DATE 3/13/2014
	SHEET 3 OF 29

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED

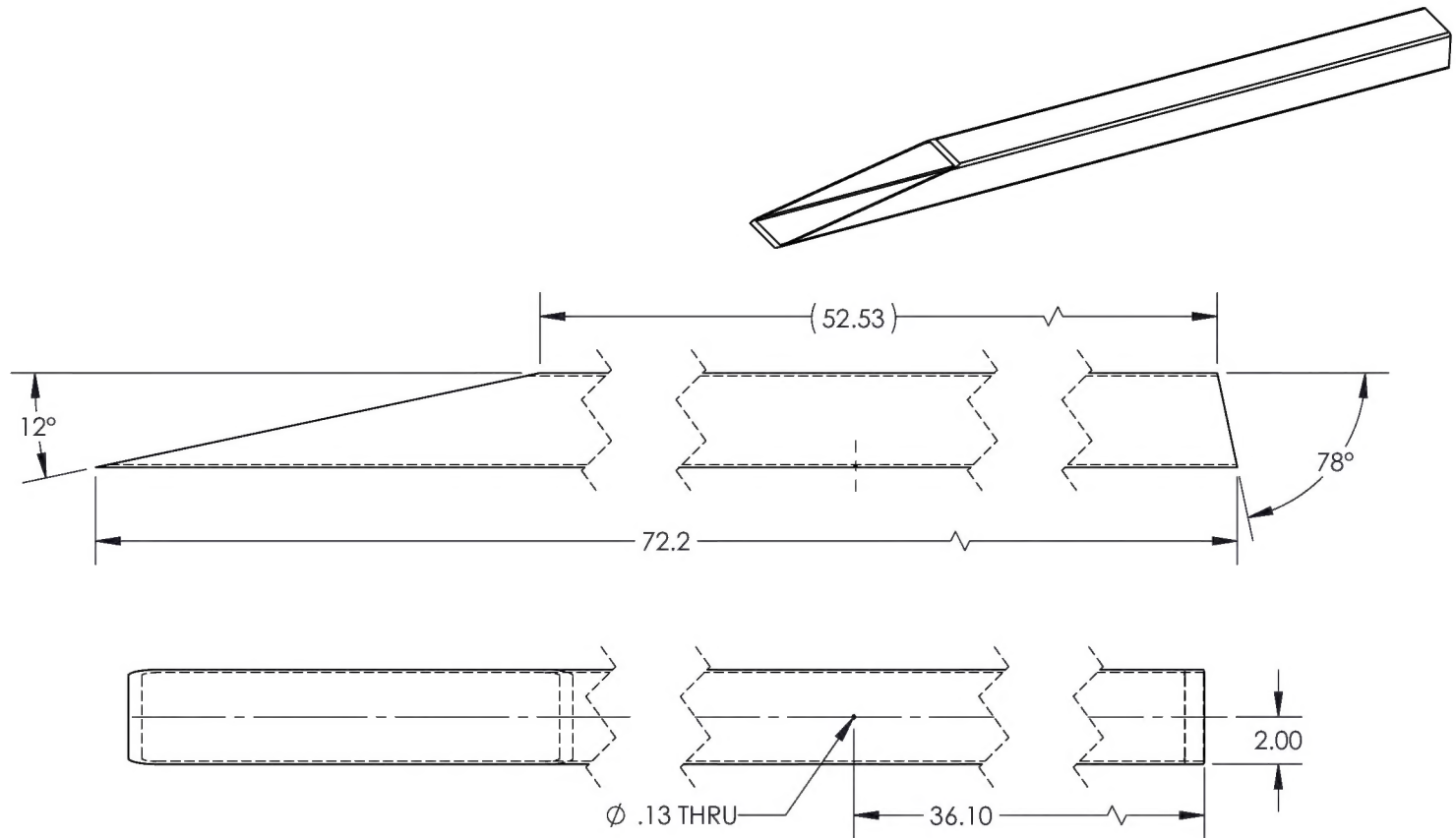
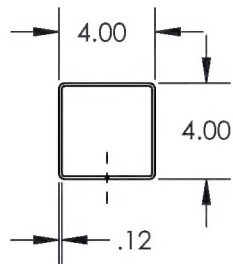


(-23)  
MAIN FRAME UPRIGHT

<b>DART AEROSPACE</b>	
TITLE <b>SUPPORT DOLLY, TAILBOOM</b>	
DWG NO. <b>RB T102012-23</b>	REV <b>1</b>
MAT'L STEEL TUBE	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -1 WELDMENT	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125°
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:4	DATE 3/13/2014
	SHEET 4 OF 29

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			INITIAL
			APPROVED



(25)

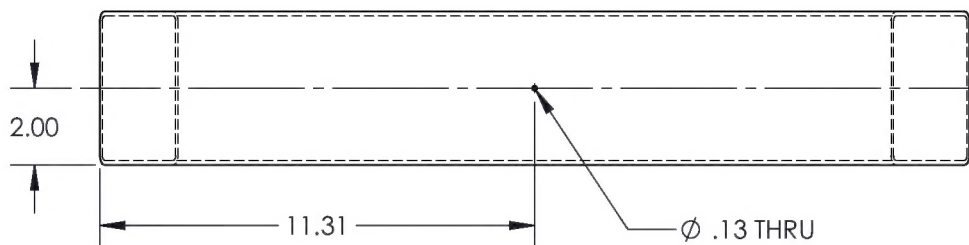
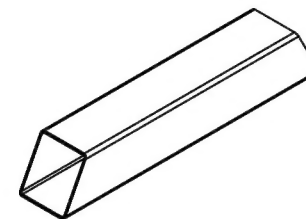
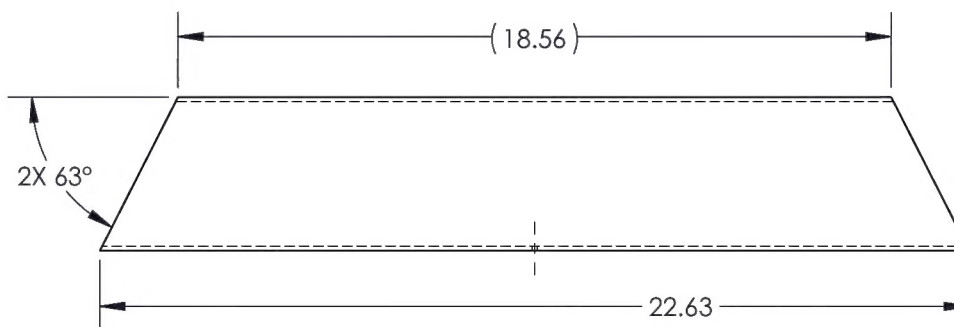
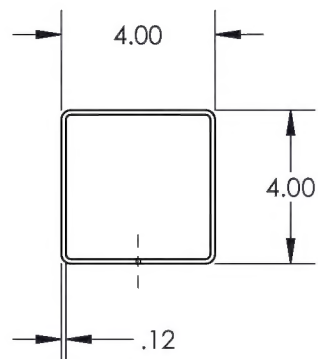
MAIN FRAME OUTSIDE BRACE

<b>DART AEROSPACE</b>	
TITLE <b>SUPPORT DOLLY, TAILBOOM</b>	
DWG NO. <b>RB T102012-25</b>	REV <b>1</b>
MAT'L STEEL TUBE	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -1 WELDMENT	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125°
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:8	DATE 3/13/2014
	SHEET 5 OF 29



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				APPROVED



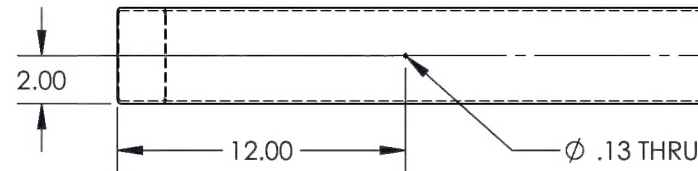
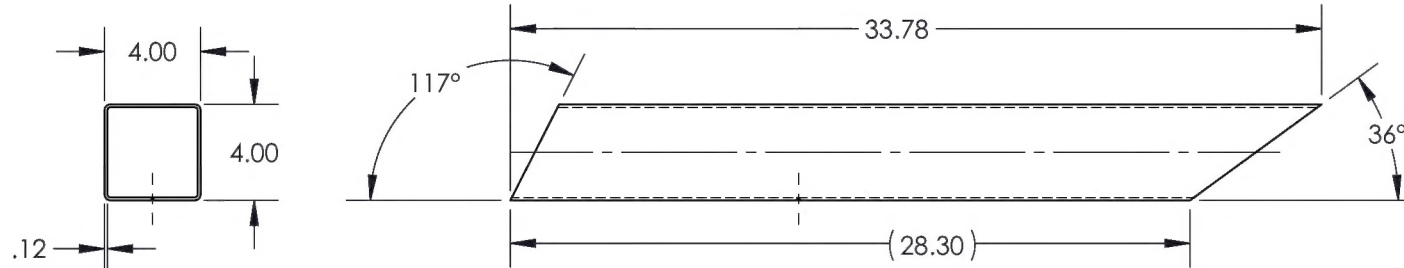
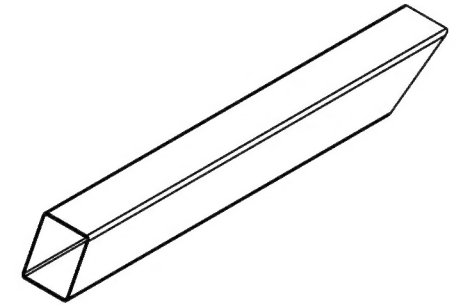
(-27)

MAIN FRAME 1 BOTTOM

<b>DART AEROSPACE</b>	
TITLE <b>SUPPORT DOLLY, TAILBOOM</b>	
DWG NO. <b>RB T102012-27</b>	REV <b>1</b>
MAT'L STEEL TUBE	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -1 WELDMENT	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125/✓
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:5	DATE 3/13/2014
	SHEET 6 OF 29

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				APPROVED



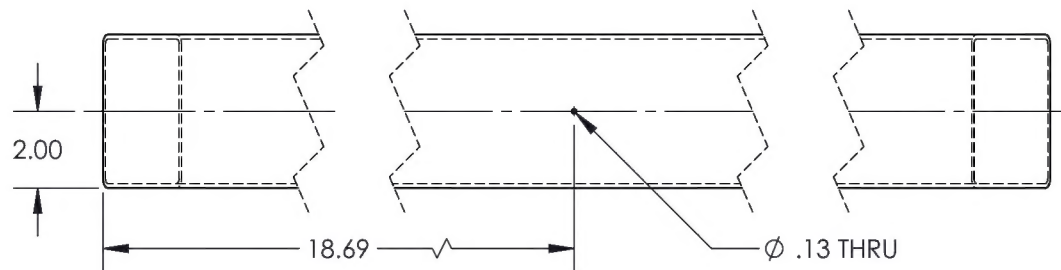
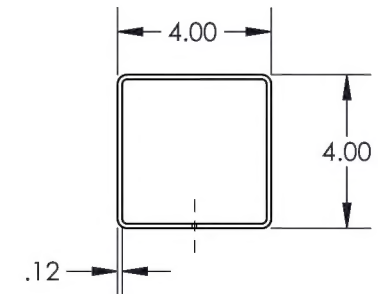
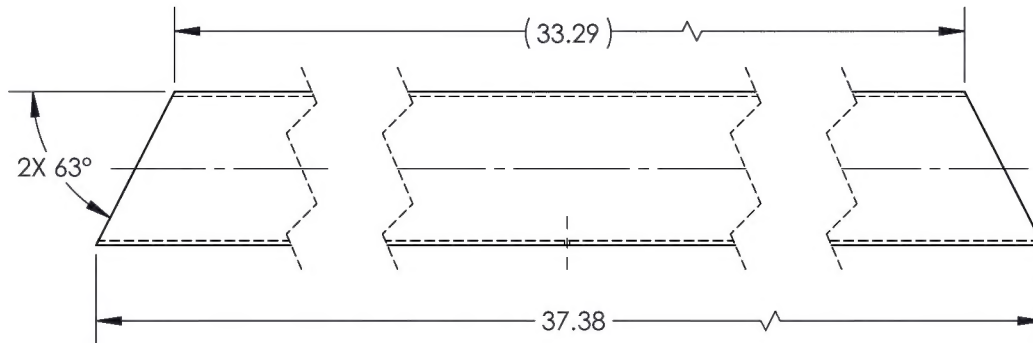
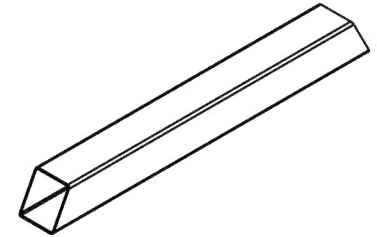
(29)

MAIN FRAME 1 SIDE

<b>DART</b> AEROSPACE	
TITLE <b>SUPPORT DOLLY, TAILBOOM</b>	
DWG NO. <b>RB T102012-29</b>	REV <b>1</b>
MAT'L STEEL TUBE	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -1 WELDMENT	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125°
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:8	DATE 3/13/2014
	SHEET 7 OF 29

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(-31)

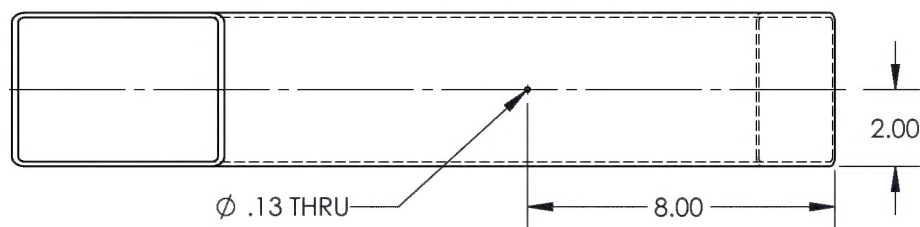
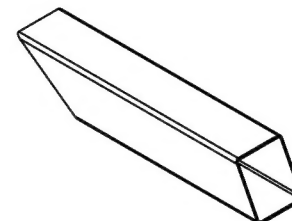
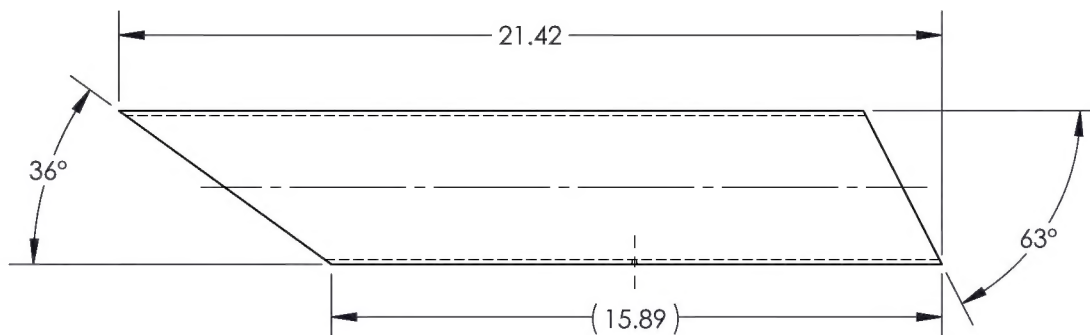
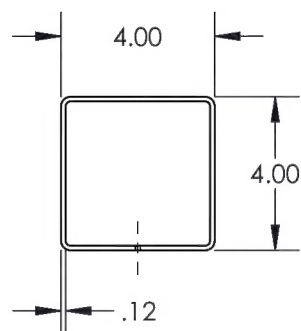
MAIN FRAME 2 BOTTOM

<b>DART AEROSPACE</b>	
TITLE <b>SUPPORT DOLLY, TAILBOOM</b>	
DWG NO. <b>RB T102012-31</b>	REV <b>1</b>
MAT'L STEEL TUBE HEAT TREAT FINISH SEE -1 WELDMENT SPEC	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125°	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: <b>GILBERT</b>	USED ON MODEL
CHECKED: <b>CLOUGH</b>	BELL 212, 214B, 214ST, 412
OPPS APPR: <b>ANDERSON</b>	
QA APPR: <b>LINDSAY</b>	
APPROVED: <b>GILBERT</b>	
SCALE <b>1:5</b>	DATE <b>3/13/2014</b>
SHEET 8 OF 29	



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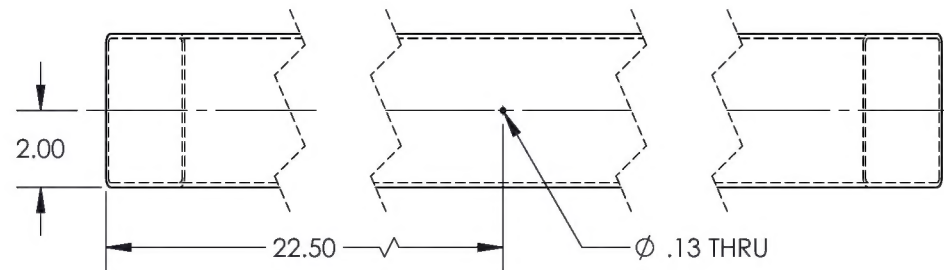
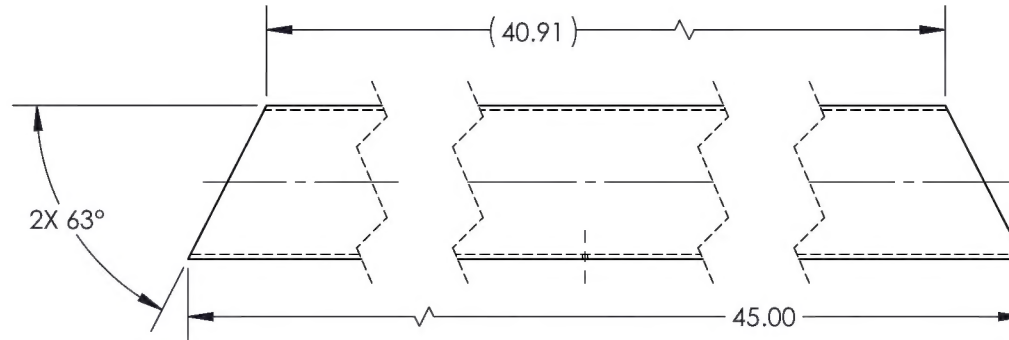
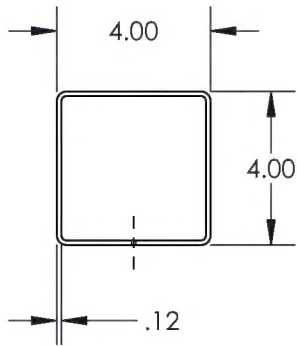
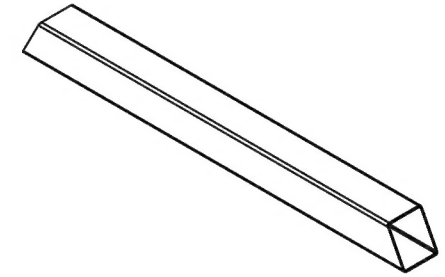
(-33)

MAIN FRAME 2 SIDE

<b>DART AEROSPACE</b>	
TITLE <b>SUPPORT DOLLY, TAILBOOM</b>	
DWG NO. <b>RB T102012-33</b>	REV <b>1</b>
MAT'L STEEL TUBE	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -1 WELDMENT	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125°
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:5	DATE 3/13/2014
	SHEET 9 OF 29

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REV	ECR	DESCRIPTION			DATE	INITIAL	APPROVED



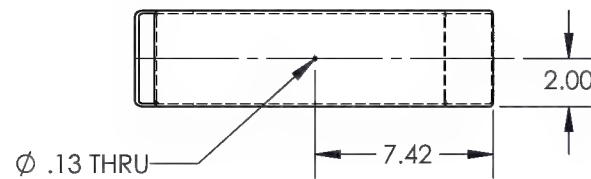
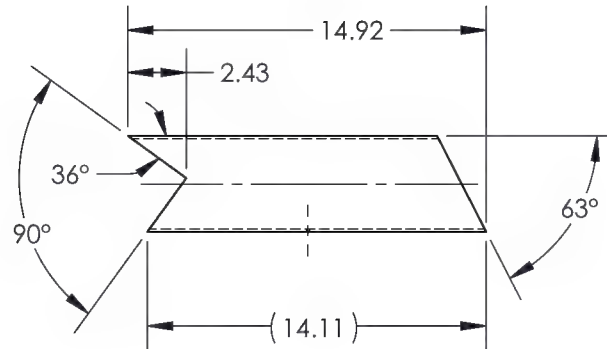
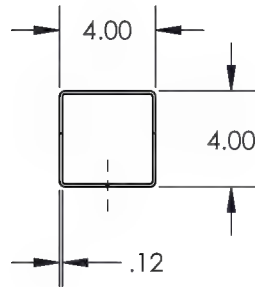
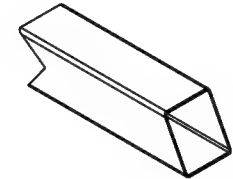
(-35)

MAIN FRAME 3 BOTTOM

<b>DART</b> AEROSPACE	
TITLE <b>SUPPORT DOLLY, TAILBOOM</b>	
DWG NO. <b>RB T102012-35</b>	REV <b>1</b>
MAT'L STEEL TUBE	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -1 WELDMENT	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125° ✓
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:5	DATE 3/13/2014
	SHEET 10 OF 29

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				APPROVED



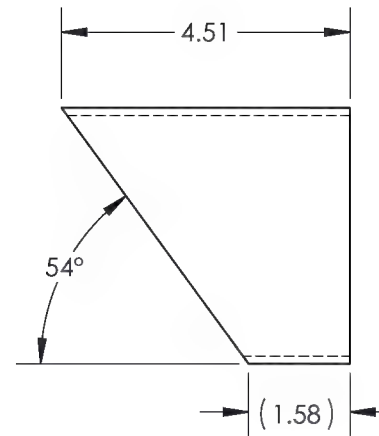
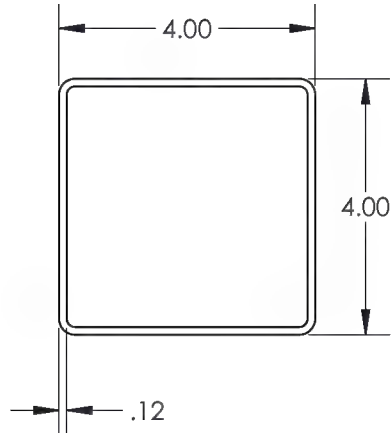
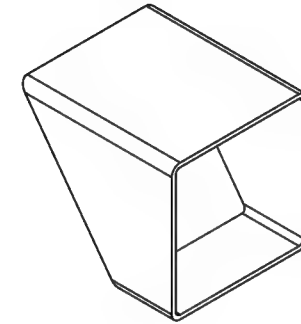
(-37)

MAIN FRAME 3 SIDE

<b>DART AEROSPACE</b>	
TITLE <b>SUPPORT DOLLY, TAILBOOM</b>	
DWG NO. <b>RB T102012-37</b>	REV <b>1</b>
MAT'L STEEL TUBE	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -1 WELDMENT	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125/✓
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:8	DATE 3/13/2014
	SHEET 11 OF 29

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



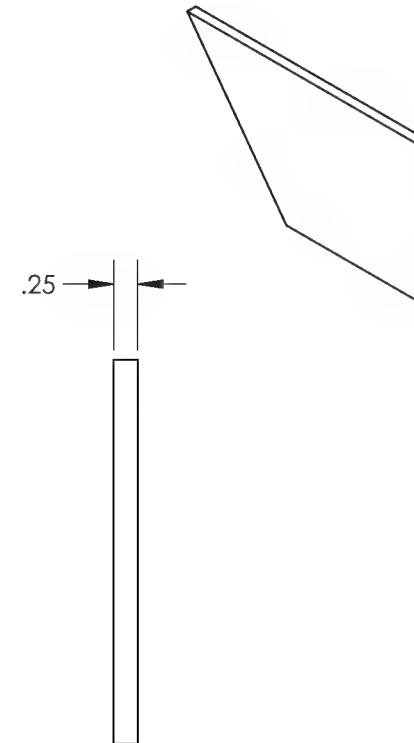
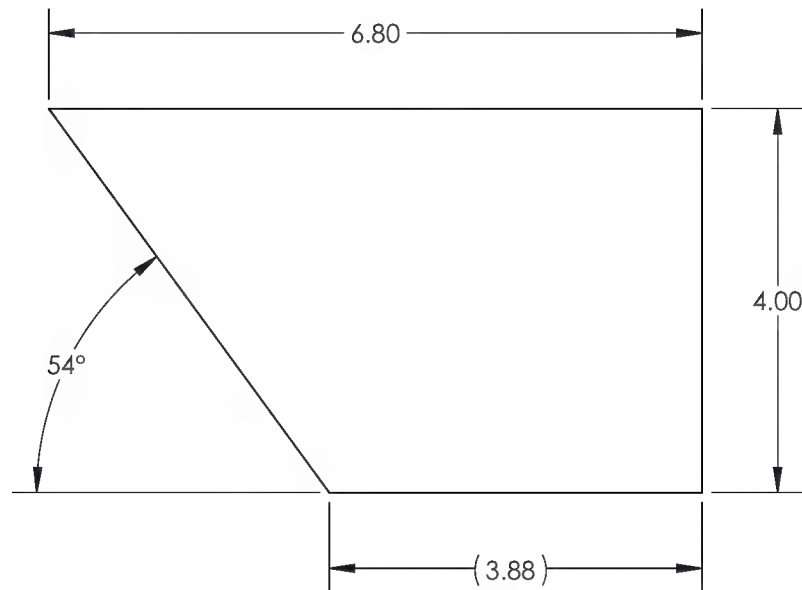
(-39)

MAIN FRAME 1 PIVOT

<b>DART AEROSPACE</b>	
TITLE <b>SUPPORT DOLLY, TAILBOOM</b>	
DWG NO. <b>RB T102012-39</b>	REV <b>1</b>
MAT'L STEEL TUBE	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -1 WELDMENT	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125/✓
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:3	DATE 3/13/2014
	SHEET 12 OF 29

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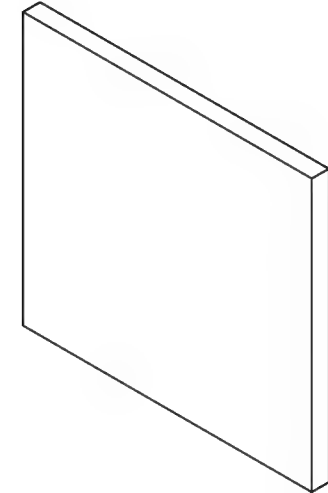
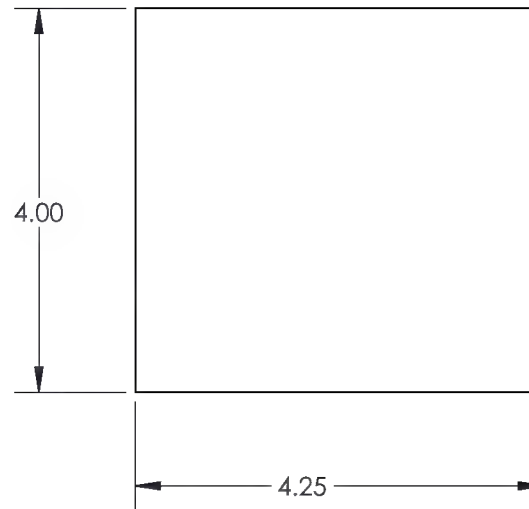
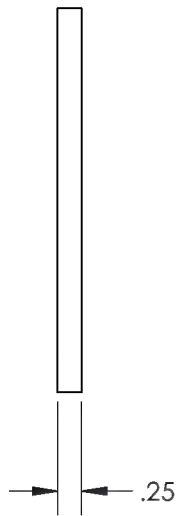
(-41)

MAIN FRAME 1 PIVOT SIDE REINFORCEMENT

<b>DART AEROSPACE</b>	
TITLE <b>SUPPORT DOLLY, TAILBOOM</b>	
DWG NO. <b>RB T102012-41</b>	REV <b>1</b>
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -1 WELDMENT	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125° ✓
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:2	DATE 3/13/2014
	SHEET 13 OF 29

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(-43)

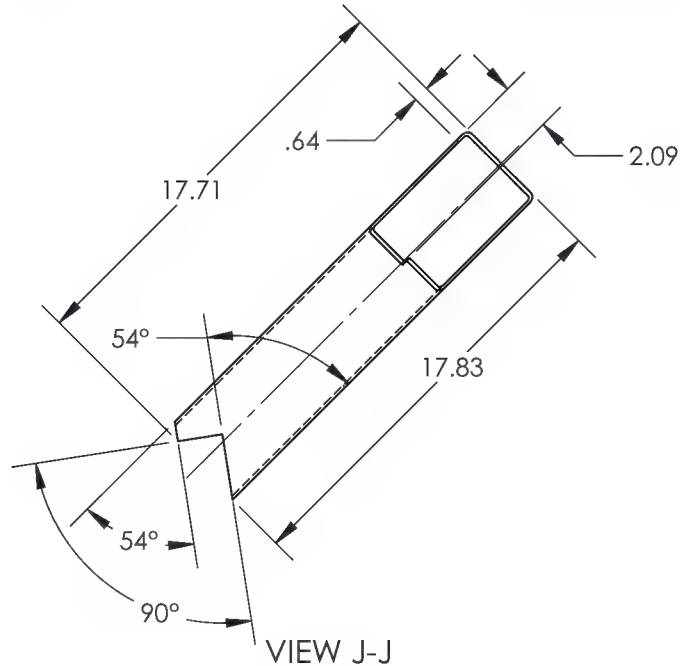
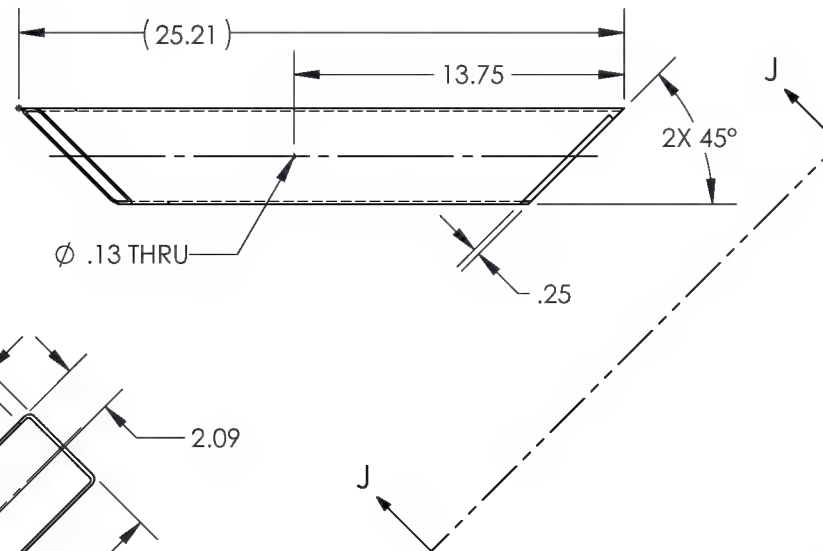
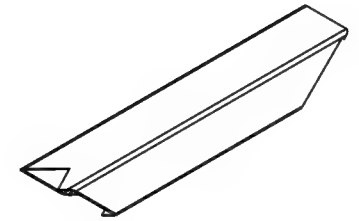
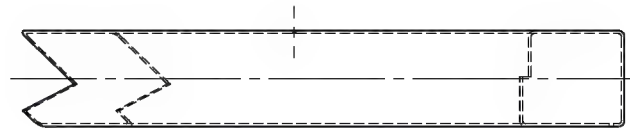
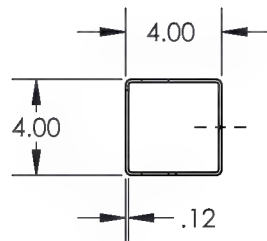
MAIN FRAME 1 PIVOT TOP REINFORCEMENT

<b>DART</b> AEROSPACE	
TITLE <b>SUPPORT DOLLY, TAILBOOM</b>	
DWG NO. <b>RB T102012-43</b>	REV <b>1</b>
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -1 WELDMENT	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125°
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:2	DATE 3/13/2014
	SHEET 14 OF 29



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VIEW J-J

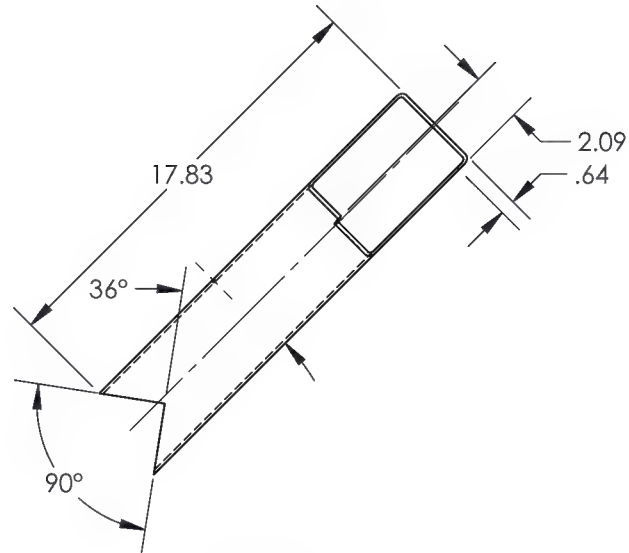
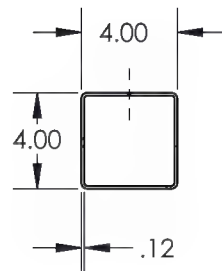
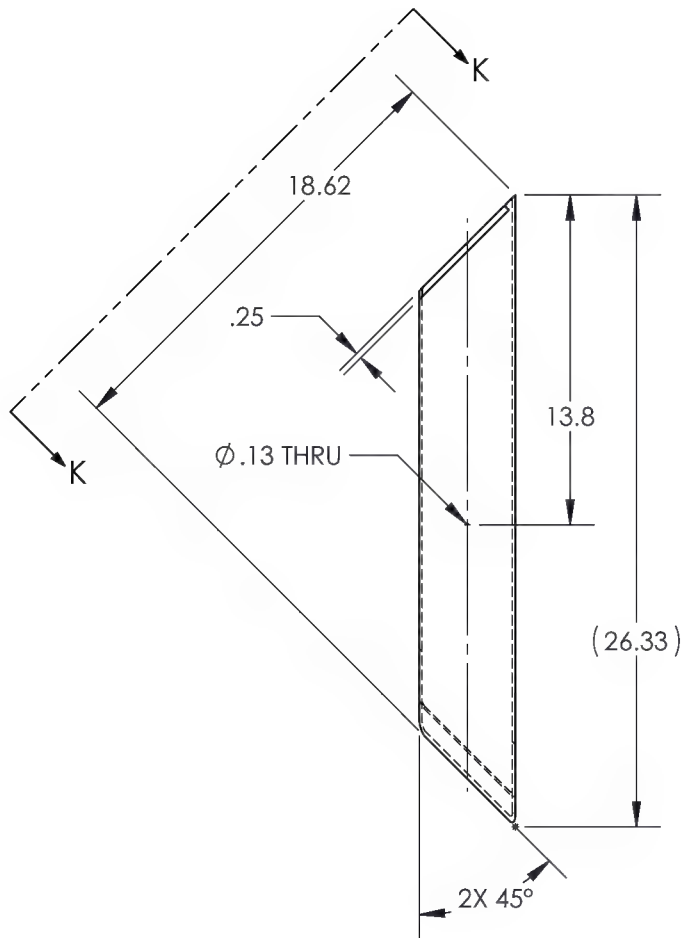
(-45)

MAIN FRAME INSIDE BRACE POWER PACK

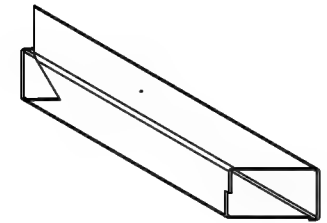
<b>DART AEROSPACE</b>	
TITLE <b>SUPPORT DOLLY, TAILBOOM</b>	
DWG NO. <b>RB T102012-45</b>	REV <b>1</b>
MAT'L STEEL TUBE	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -1 WELDMENT	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125° ✓
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:8	DATE 3/13/2014
	SHEET 15 OF 29

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VIEW K-K



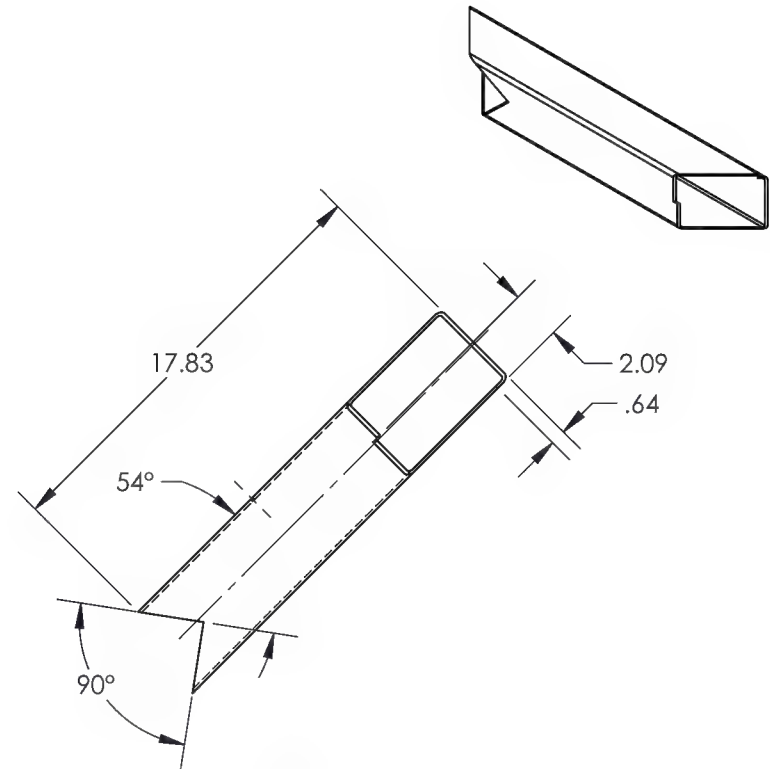
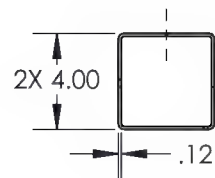
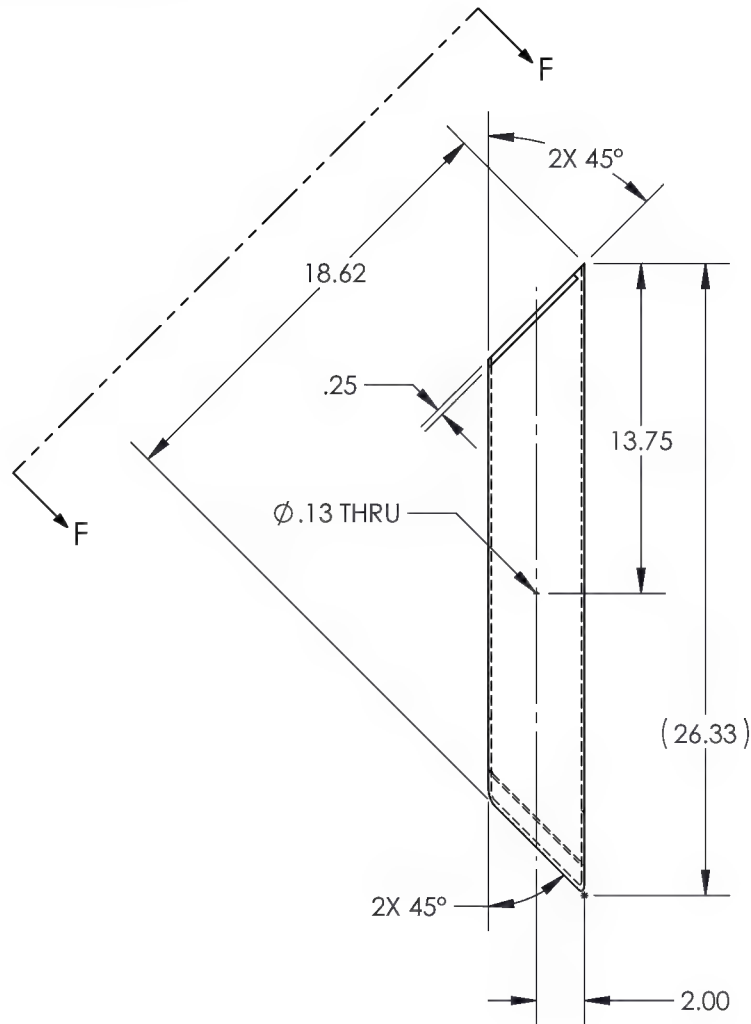
<b>DART</b> AEROSPACE	
TITLE <b>SUPPORT DOLLY, TAILBOOM</b>	
DWG NO. <b>RB T102012-47</b>	REV <b>1</b>
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -1 WELDMENT	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125° ✓
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:8	DATE 3/13/2014
	SHEET 16 OF 29

MAIN FRAME INSIDE BRACE MIRROR

(-47)

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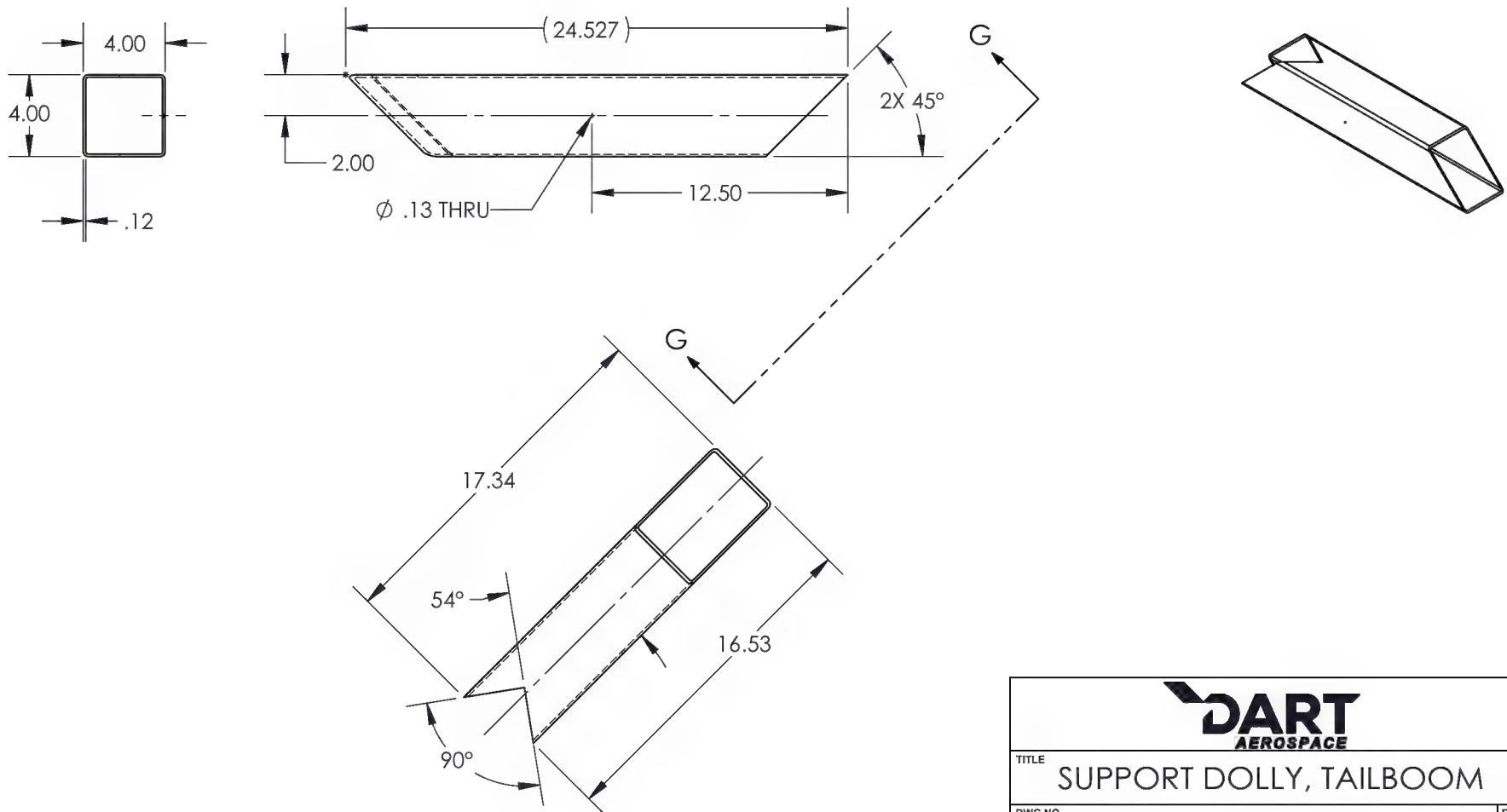
VIEW F-F

MAIN FRAME INSIDE BRACE

<b>DART</b> AEROSPACE	
TITLE <b>SUPPORT DOLLY, TAILBOOM</b>	
DWG NO. <b>RB T102012-49</b>	REV <b>1</b>
MAT'L STEEL TUBE HEAT TREAT FINISH SEE -1 WELDMENT SPEC	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY:	GILBERT
CHECKED:	CLOUGH
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
USED ON MODEL	
BELL 212, 214B, 214ST, 412	
SCALE 1:8	DATE 3/13/2014
SHEET 17 OF 29	

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				APPROVED



VIEW G-G

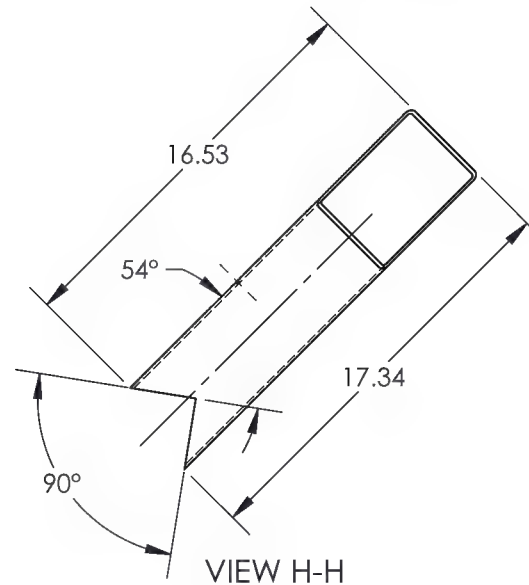
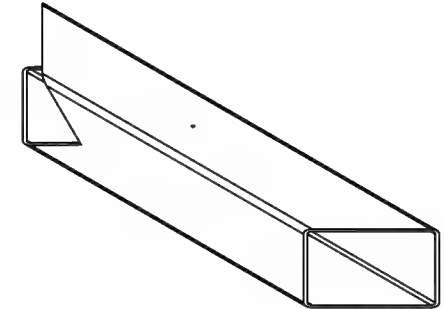
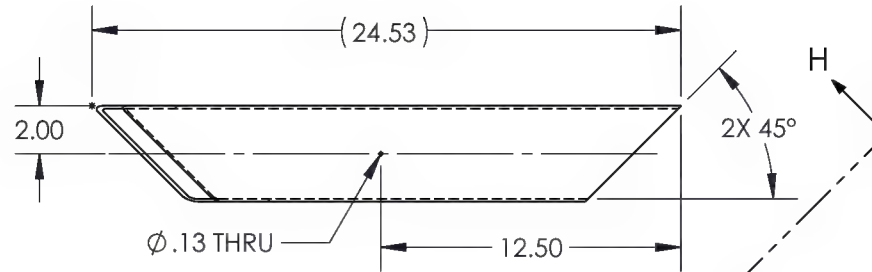
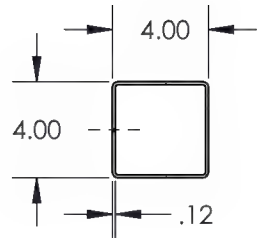
(-51)

MAIN FRAME TB INSIDE BRACE

<b>DART</b> AEROSPACE	
TITLE <b>SUPPORT DOLLY, TAILBOOM</b>	
DWG NO. <b>RB T102012-51</b>	REV <b>1</b>
MAT'L STEEL TUBE HEAT TREAT FINISH SEE -1 WELDMENT SPEC	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125° ✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: <b>GILBERT</b>	USED ON MODEL
CHECKED: <b>CLOUGH</b>	
OPPS APPR: <b>ANDERSON</b>	
QA APPR: <b>LINDSAY</b>	
APPROVED: <b>GILBERT</b>	<b>BELL 212, 214B, 214ST, 412</b>
SCALE <b>1:8</b>	DATE <b>3/13/2014</b>
SHEET 18 OF 29	

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VIEW H-H

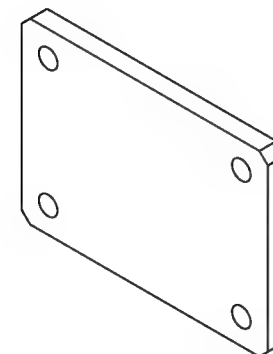
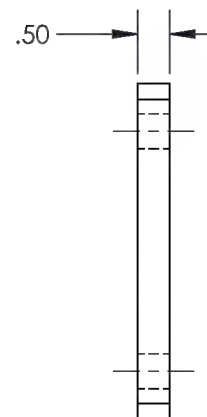
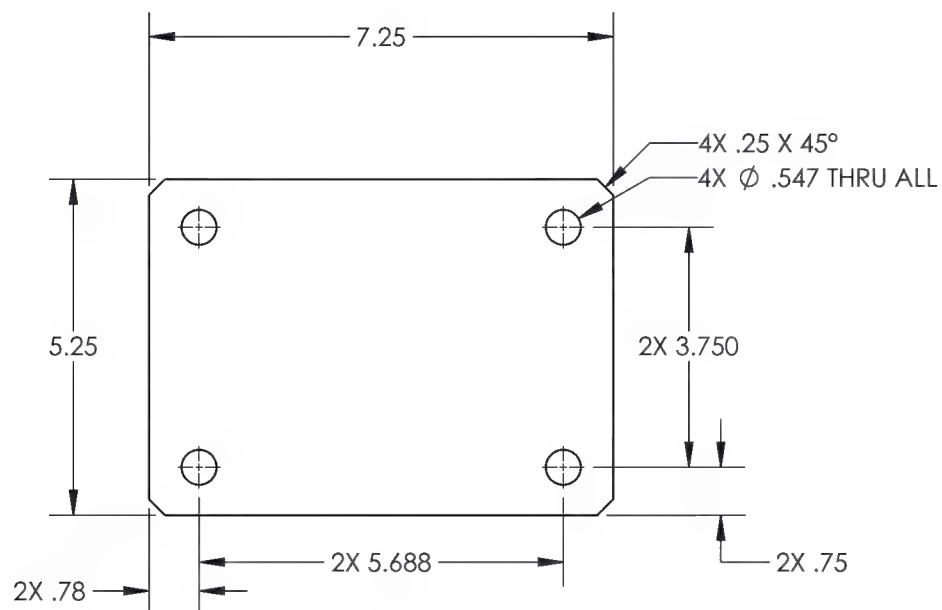
(-53)

MAIN FRAME TB INSIDE BRACE MIRROR

<b>DART AEROSPACE</b>	
TITLE <b>SUPPORT DOLLY, TAILBOOM</b>	
DWG NO. <b>RB T102012-53</b>	REV <b>1</b>
MAT'L STEEL TUBE	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -1 WELDMENT	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125° ✓
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:8	DATE 3/13/2014
	SHEET 19 OF 29

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(-55)

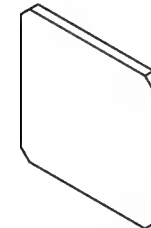
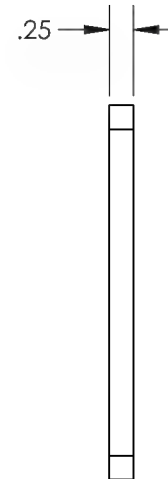
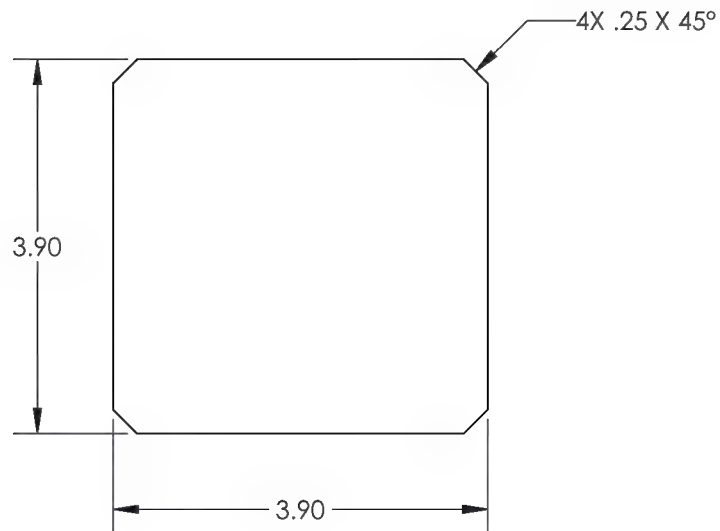
MAIN FRAME WHEEL PLATE

<b>DART</b> AEROSPACE	
TITLE <b>SUPPORT DOLLY, TAILBOOM</b>	
DWG NO. <b>RB T102012-55</b>	REV <b>1</b>
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -1 WELDMENT	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125°
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
	USED ON MODEL
	BELL 212, 214B, 214ST, 412
SCALE 1:3	DATE 3/13/2014
	SHEET 20 OF 29



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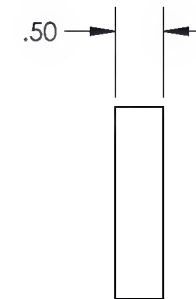
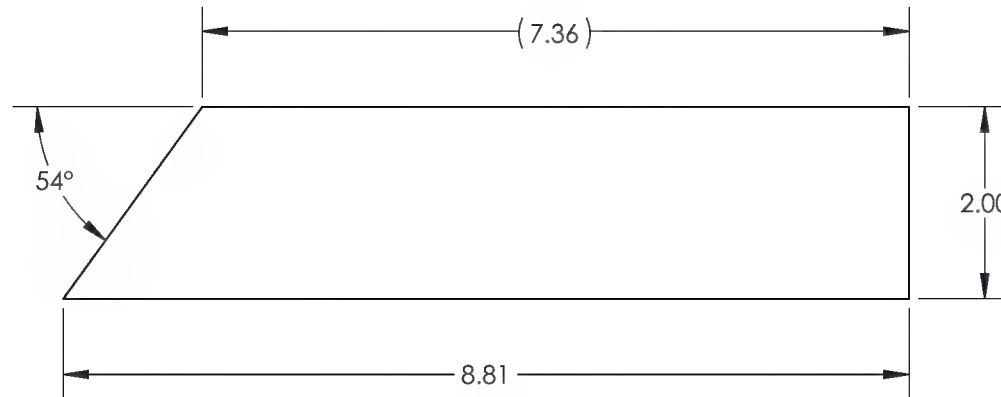
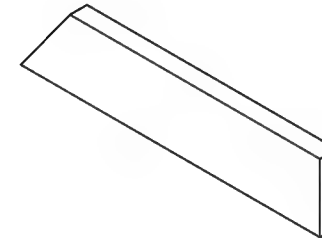


(-57)  
MAIN FRAME END CAP

<b>DART AEROSPACE</b>	
TITLE <b>SUPPORT DOLLY, TAILBOOM</b>	
DWG NO. <b>RB T102012-57</b>	REV <b>1</b>
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -1 WELDMENT	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125° ✓
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:2	DATE 3/13/2014
	SHEET 21 OF 29

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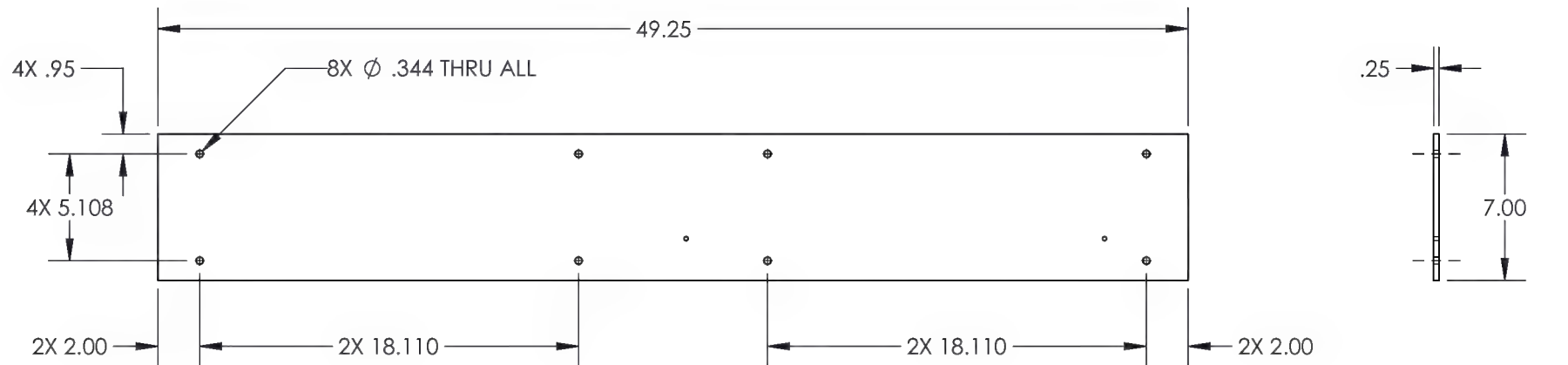
-59

MAIN FRAME 2 UPRIGHT BRACE

<b>DART</b> AEROSPACE	
TITLE <b>SUPPORT DOLLY, TAILBOOM</b>	
DWG NO. <b>RB T102012-59</b>	REV <b>1</b>
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -1 WELDMENT	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125°
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
	USED ON MODEL
	BELL 212, 214B, 214ST, 412
SCALE 1:2	DATE 3/13/2014
	SHEET 22 OF 29

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REV	ECR	DESCRIPTION	DATE



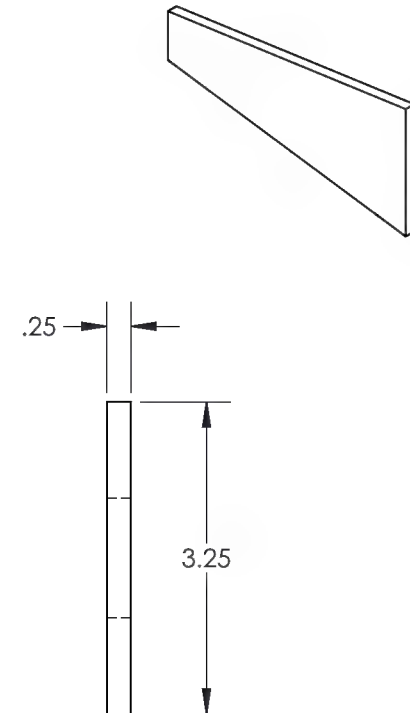
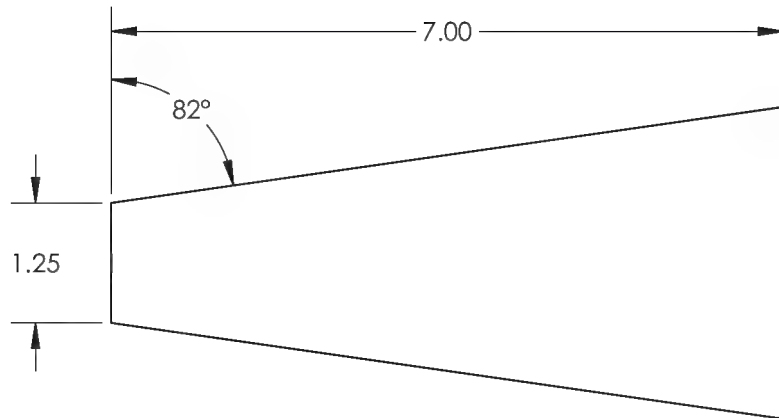
(-61)

MAIN FRAME POWER PACK BASE

<b>DART</b> AEROSPACE	
TITLE <b>SUPPORT DOLLY, TAILBOOM</b>	
DWG NO. <b>RB T102012-61</b>	REV <b>1</b>
MAT'L <b>A36/1018/1020 HR</b>	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT <b>SEE -1 WELDMENT</b>	.XXX $\pm$ .010 FRACTIONS $\pm$ 1/8
FINISH <b>SEE -1 WELDMENT</b>	.XX $\pm$ .03 ANGLES $\pm$ 1°
SPEC	.X $\pm$ .1 SURFACES = 125° ✓
DRAWN BY: <b>GILBERT</b>	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: <b>CLOUGH</b>	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: <b>ANDERSON</b>	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: <b>LINDSAY</b>	USED ON MODEL
APPROVED: <b>GILBERT</b>	<b>BELL 212, 214B, 214ST, 412</b>
SCALE <b>1:8</b>	DATE <b>3/13/2014</b>
SHEET 23 OF 29	

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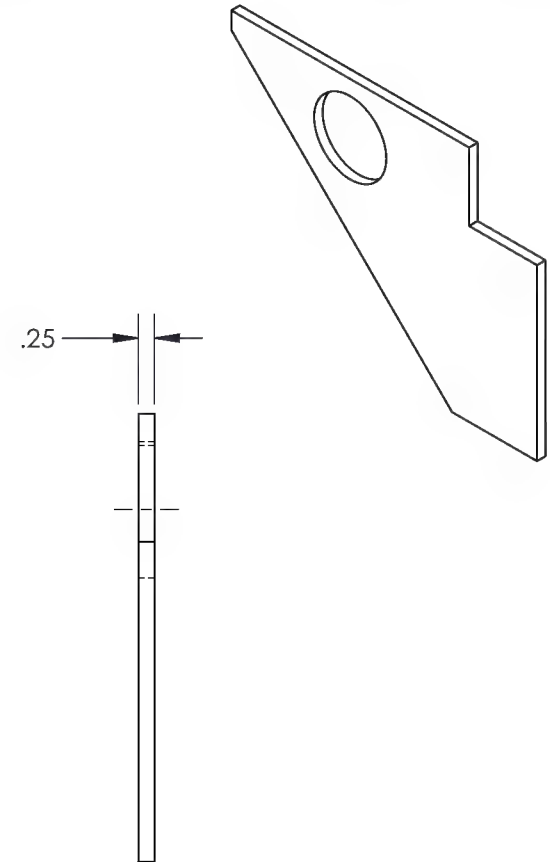
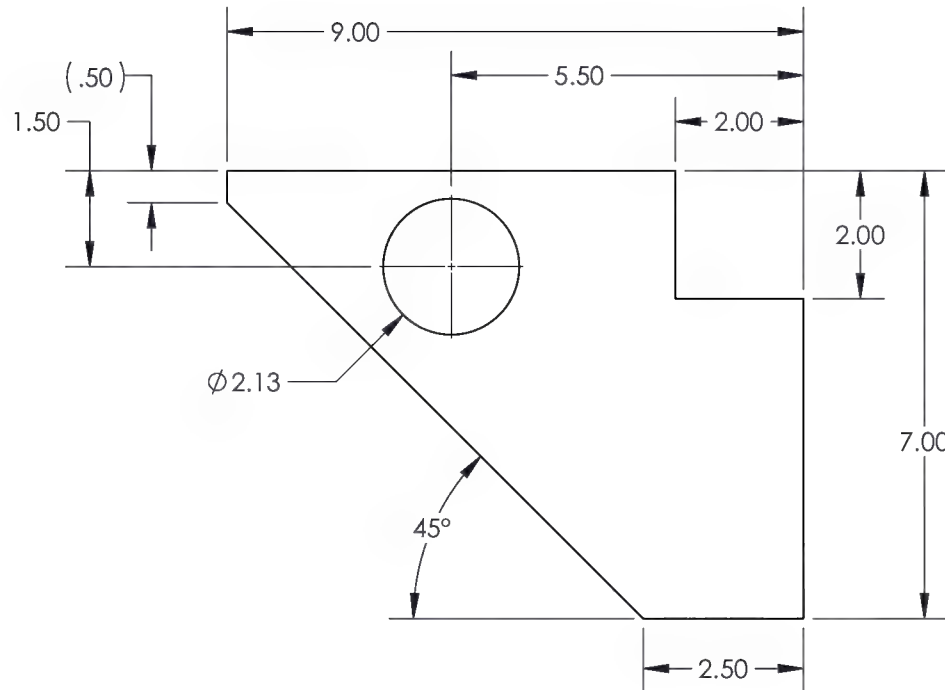
(-63)

MAIN FRAME POWER PACK GUSSET

<b>DART AEROSPACE</b>	
TITLE <b>SUPPORT DOLLY, TAILBOOM</b>	
DWG NO. <b>RB T102012-63</b>	REV <b>1</b>
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -1 WELDMENT	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125°
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:2	DATE 3/13/2014
	SHEET 24 OF 29

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			INITIAL
			APPROVED



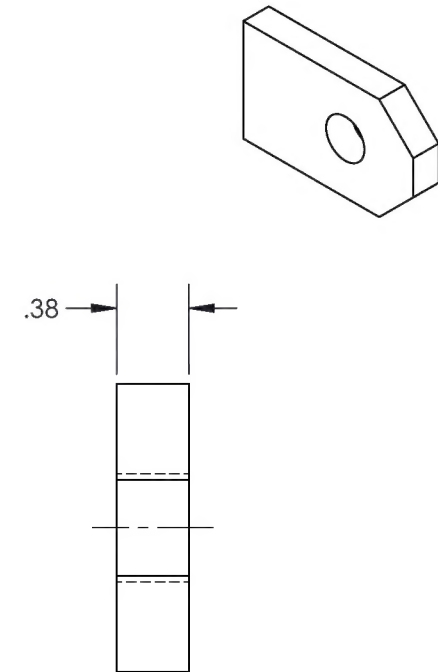
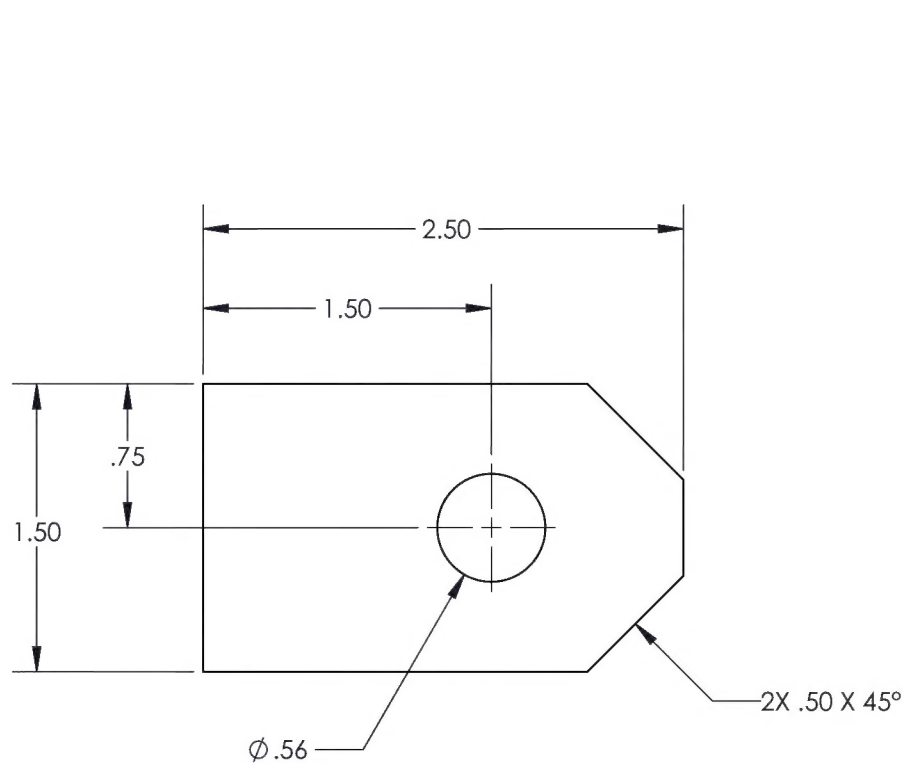
(-65)

MAIN FRAME POWER PACK GUSSET 2

<b>DART AEROSPACE</b>	
TITLE <b>SUPPORT DOLLY, TAILBOOM</b>	
DWG NO. <b>RB T102012-65</b>	REV <b>1</b>
MAT'L <b>A36/1018/1020 HR</b>	UNLESS OTHERWISE SPECIFIED
HEAT <b>TREAT</b>	DIMENSIONS ARE IN INCHES
FINISH <b>SEE -1 WELDMENT</b>	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125°
DRAWN BY: <b>GILBERT</b>	1. BREAK ALL SHARP EDGES
CHECKED: <b>CLOUGH</b>	.015 x 45° OR .015R
OPPS APPR: <b>ANDERSON</b>	2. DIMENSIONAL LIMITS APPLY
QA APPR: <b>LINDSAY</b>	AFTER PLATING
APPROVED: <b>GILBERT</b>	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE <b>1:3</b>	DATE <b>3/13/2014</b>
	SHEET 25 OF 29

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



(-67)

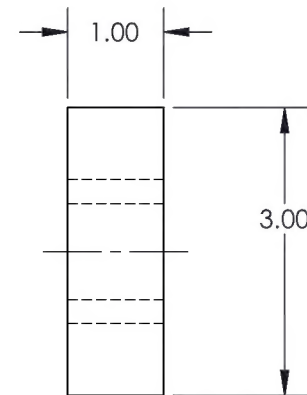
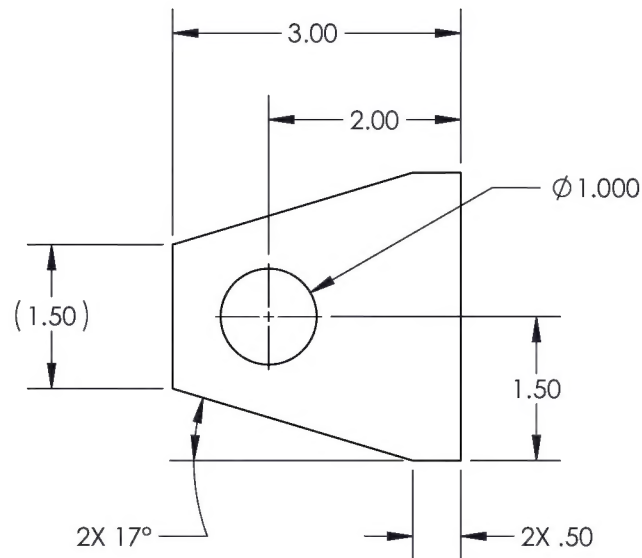
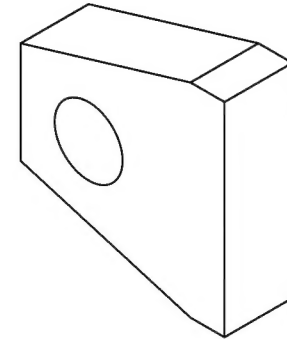
MAIN FRAME TOWBAR MOUNT

<b>DART</b> AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-67	REV 1
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -1 WELDMENT	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125°
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:1	DATE 3/13/2014
	SHEET 26 OF 29



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				APPROVED



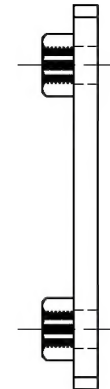
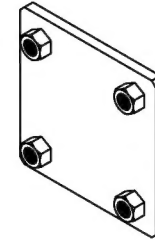
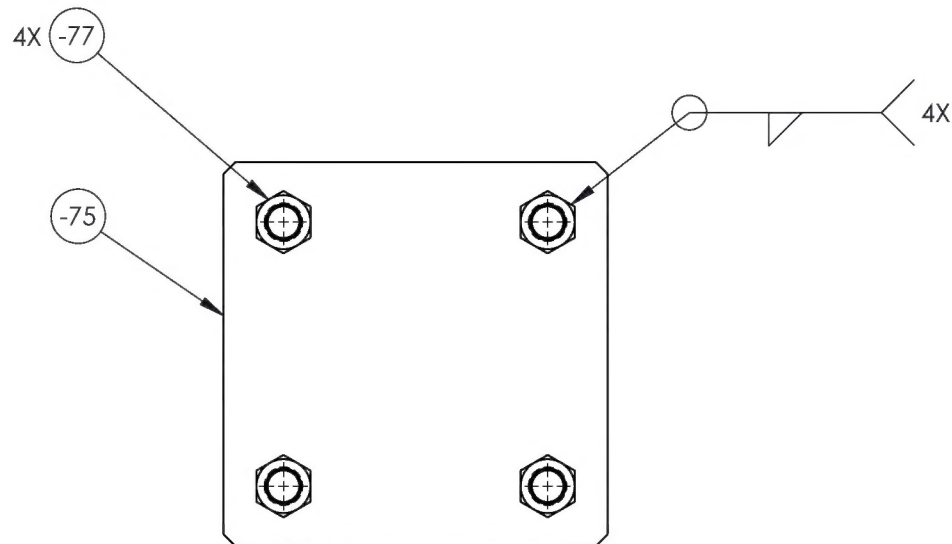
-69

MAIN FRAME 1 PISTON TAB

<b>DART</b> AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-69	REV 1
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -1 WELDMENT	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125°
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:2	DATE 3/13/2014
	SHEET 27 OF 29

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				APPROVED



(-73)

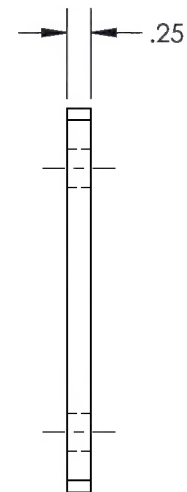
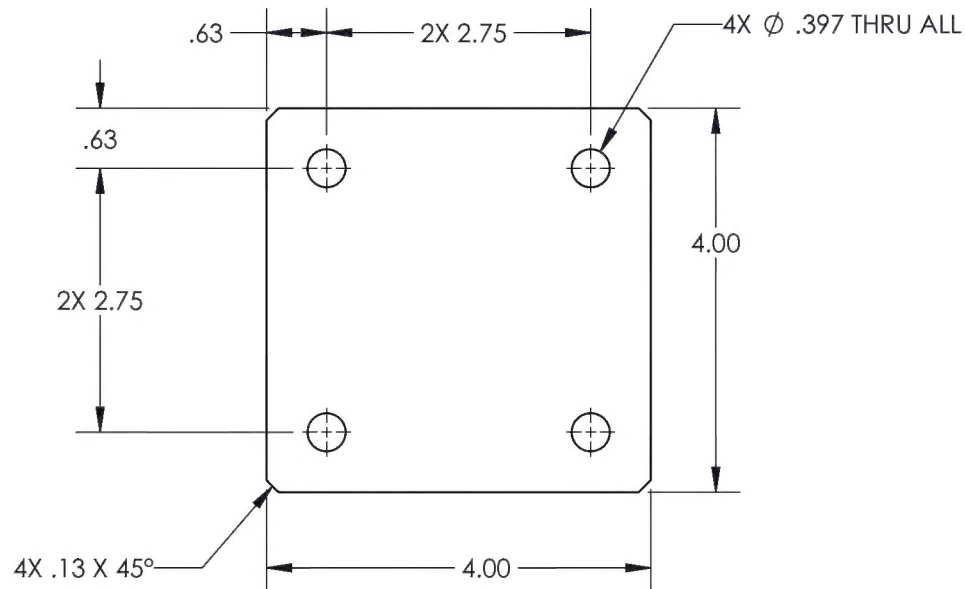
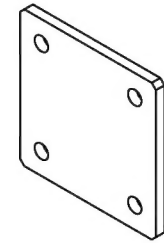
WELDED PIVOT PLATE ASSEMBLY



TITLE		SUPPORT DOLLY, TAILBOOM	
DWG NO.		RB T102012-73	
		REV 1	
MAT'L		UNLESS OTHERWISE SPECIFIED	
HEAT		DIMENSIONS ARE IN INCHES	
TREAT		.XXX ± .010 FRACTIONS ± 1/8	
FINISH SEE -1 WELDMENT		.XX ± .03 ANGLES ± 1°	
		.X ± .1 SURFACES = 125°	
SPEC		1. BREAK ALL SHARP EDGES	
DRAWN BY: GILBERT		.015 x 45° OR .015R	
CHECKED: CLOUGH		2. DIMENSIONAL LIMITS APPLY	
OPPS APPR: ANDERSON		AFTER PLATING	
QA APPR: LINDSAY		3. INTERPRET DIM AND TOL PER	
APPROVED: GILBERT		ASME Y14.5M-2009	
SCALE 1:2		DATE 3/13/2014	
		SHEET 28 OF 29	

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				APPROVED



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MAIN FRAME WELD PIVOT PLATE

<b>DART</b> AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-75	REV 1
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -1 WELDMENT	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125°
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:2	DATE 3/13/2014
	SHEET 29 OF 29